



Dart Aerospace Ltd.
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Tel (613) 632-5200

D350-591-312
Job Sheet 164051



Part No: D350-591-312

Job Qty: 10 ea

Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 12/22/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/20/17	12/20/17	0.00	0.00	Start Up Large Fab-2		CPC
100	DC	10 pcs	12/20/17	12/20/17	0.00	0.00	DC		CPC
110	Large Fab	10 pcs	12/21/17	12/21/17	0.00	10.00	Large Fab 2		CPC
120	QC	10 pcs	12/21/17	12/21/17	0.00	0.00	QC9		PD 18-1-5
130	QC	10 pcs	12/21/17	12/21/17	0.00	0.00	QC5		PD 18-1-3
140	HandFinish	10 pcs	12/21/17	12/21/17	0.00	1.87	HandFinish1		3y AP 18-01-08
150	QC	10 pcs	12/21/17	12/21/17	0.00	0.00	QC7		PD 18-01-09
180	Large Fab	10 pcs	12/21/17	12/21/17	0.00	10.00	Large Fab 2		SL 1/10/18
190	QC	10 pcs	12/21/17	12/21/17	0.00	0.00	QC10		PD 18-01-10
200	QC	10 pcs	12/21/17	12/21/17	0.00	0.00	QC5		PD 18-01-10
210	HandFinish	10 pcs	12/21/17	12/21/17	0.00	1.87	HandFinish1		BER 18/01/11
220	Powdercoat	10 pcs	12/21/17	12/21/17	0.00	2.98	Powdercoat1		PR 18-01-11
230	HandFinish	10 pcs	12/22/17	12/22/17	0.00	1.87	HandFinish3		BER 18-01
240	QC	10 pcs	12/22/17	12/22/17	0.00	0.00	QC3		11 JAN 16 2018
250	Packaging	10 pcs	12/22/17	12/22/17	0.00	0.00	Packaging1		9-89
260	QC	10 pcs	12/22/17	12/22/17	0.00	0.00	QC4		smB
270	Packaging	10 pcs	12/22/17	12/22/17	0.00	0.00	Packaging3		smB
280	QC21-FG	10 Ea	12/22/17	12/22/17	0.00	0.00	QC21		21 JAN 24 2016

Part Op 100 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Descriptions: 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:15 OVEN TEMPERATURE: 320° FINISH TIME: 2:45

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3067-1 S012005	10	37	0	0
	D3219-1 S016525	20	28	0	0
	D3272-1 S025406	10	0	0	0
180-Large Fab	S030236 → D3065-041 F166S14	10	21	0	0
	D3066-1 S012395	20	104	0	0
	D3067-1 S012005	10	37	0	0
	MS20600-AD4W4	160	1,219	0	0
250-Packaging	S016823 AN3-35A S033026	20 18	302 2	0	0
	S033025 AN4-13A S017091 x23	80 872	941 8	0	0
	AN5-36A S033010	20 18	130 2	0	0
	D2230-3 S033007	40 36	153 4	0	0
	D2618 S033004	20 18	33 2	0	0
	D2856-400-700 S033000 x2=14	155 2	155 2	0	0
	D3235-1 S032997	20 18	85 2	0	0
	D3278-041 S032991	10 9	38 1	0	0
	MS21042L3 S032988	20 18	4,177 2	0	0
	MS21042L4 S032984	80 72	4,130 8	0	0
	MS21042L5 S032970	20 18	893 2	0	0
	NAS1149D0363J S032966	40 36	4,643 4	0	0
	NAS1149D0463J S032959	160 144	4,434 16	0	0
	NAS1149D0563J S032943	40 36	594 4	0	0

Part Specifications

Specifications could not be found.

Plex 12/18/17 11:53 AM dart.leroux.jason

DART
AEROSPACE
S027220

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Heli - Access - Step RH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 - 591 - 312

Original Serial #: S027220

Revision:

Operation:

Change No:

Packaging

CHG002

Mfg Date: 12/28/17

Job No: 164051

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

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Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]